

Work Order ID 153347

153347

Page 1

Thursday, November 17, 2016 9:15:00 AM

Item ID: D3885-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Standard Web
Start Date: 11/17/2016 Start Qty: 6.00 *6* Cust Item ID:
Required Date: 11/30/2016 Req'd Qty: 6.00 *6* Customer:

Reference: DAS 13 NOV 17 2016
Approvals: Process Plan: 9-89 Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3885	C								

108 0.00
108
Purchasing Memo 334.64
Purchasing Issue P/O: 34329
Supplier: WEJAY
Machine as per Dwg D3885
Conformity sheet required
6 NOV 21 2016 DAS 13 9-89

110 0.00
110
Packaging Memo 0.01
Packaging
6 8/16-11-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																																		
Description Work Order Deviation				Disposition				Completed By																																																																	
								Lead hand / Supervisor Approval Verification																																																																	
								QC / QA Coordinator Approval																																																																	
Root Cause				FAULT CATEGORY																																																																					
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Work Order ID 153347***153347***

Page 2

Thursday, November 17, 2016 9:15:00 AM

Item ID: D3885-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Standard Web
Start Date: 11/17/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 11/30/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									DAS
QC	Memo	0.02							9
Quality Control	USE DT10253 INSPECTION TEMPLATE								9-89
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.17							
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00							
140									
QC	Memo	0.01							
Quality Control									

6 16-12-6 [Signature]

~~6 16-12-06~~

DAS 03 9-89 6 16-12-7

Work Order ID 153347***153347***

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Thursday, November 17, 2016 9:15:00 AM

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QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.01							
Packaging	LOCATION: LG002								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.10							
Quality Control									

DAS 03 9-89

16-12-7

16/12/8

VS 16/12/07/

DAS 21 9-89

Picklist Print

Thursday, November 17, 2016 9:14:58 AM

Page 1

Work Order ID: 153347

153347

Parent Item: D3885-1

D3885-1

Parent Item Name: Standard Web

Start Date: 11/17/2016

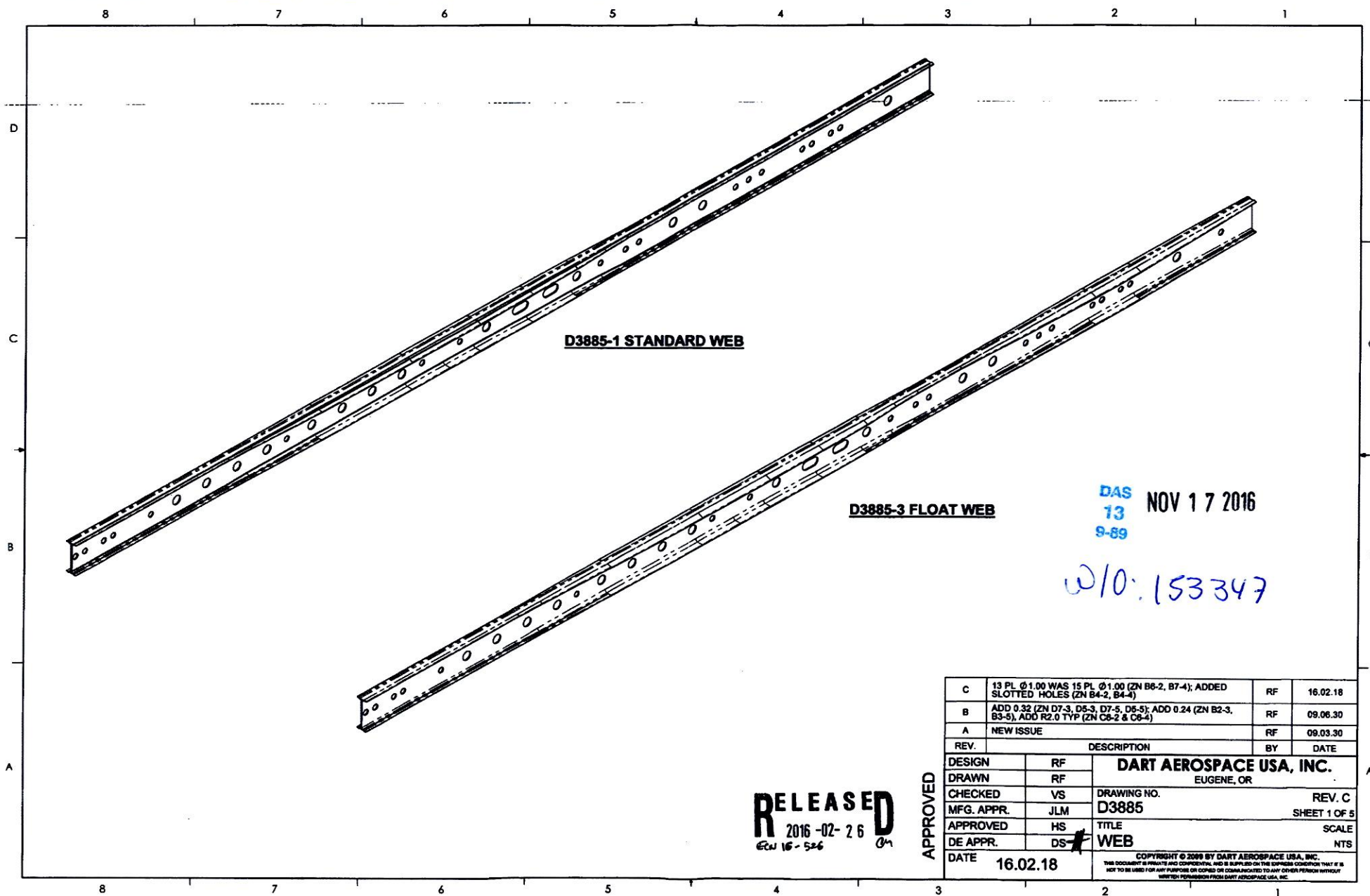
Required Date: 11/30/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3882-1-130 *D3882-1-130* Extrusion "I" Beam		Manufactured	No			110	Each	0.0000	1	6			DAS 13 9-89
D3885-1P *D3885-1P* Standard Web		Purchased	No				Each	0.0000		6			6x 5016-11-30

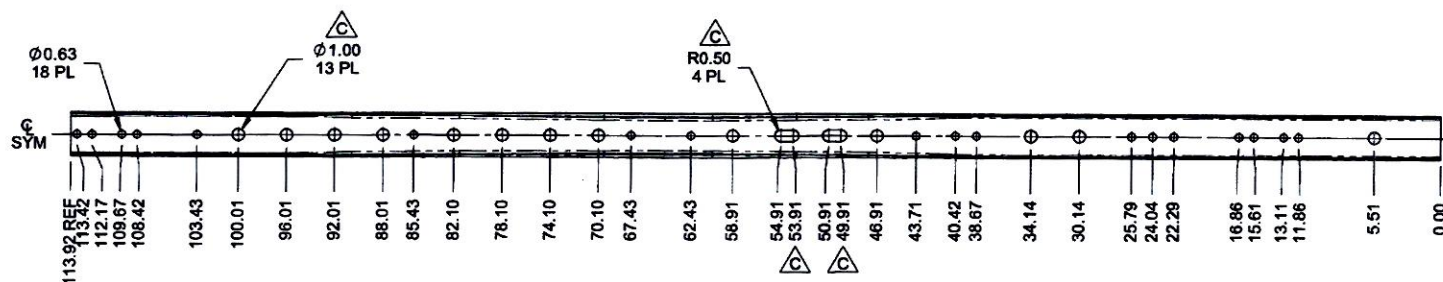
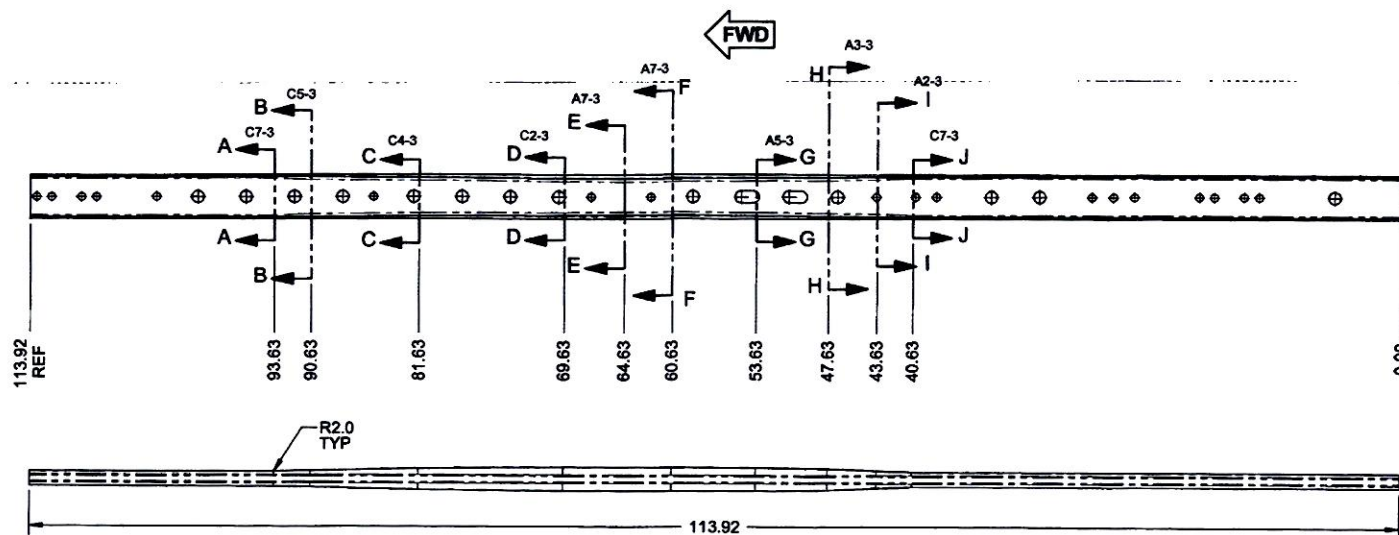


DAS
13
9-89

NOV 17 2016

W/0.153347

C	13 PL Ø1.00 WAS 15 PL Ø1.00 (ZN B6-2, B7-4); ADDED SLOTTED HOLES (ZN B4-2, B4-4)	RF	16.02.18
B	ADD 0.32 (ZN D7-3, D5-3, D7-5, D5-5); ADD 0.24 (ZN B2-3, B3-5); ADD R2.0 TYP (ZN C6-2 & C6-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3885	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEB	NTS
DATE	16.02.18	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3885-1 STANDARD WEB

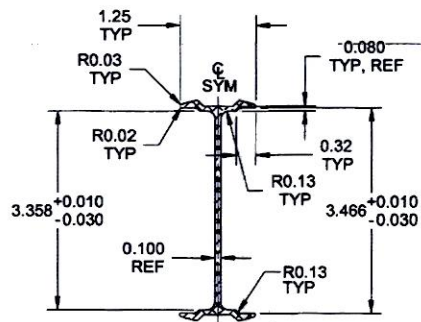
D3885-1 NOTES:

- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.49 lbs

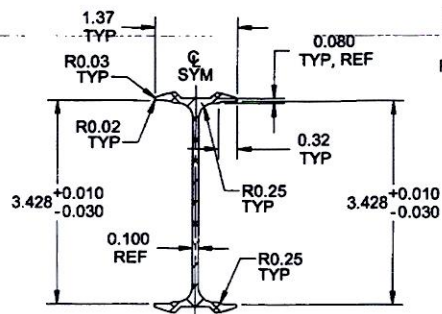
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2016-02-26

APPROVED

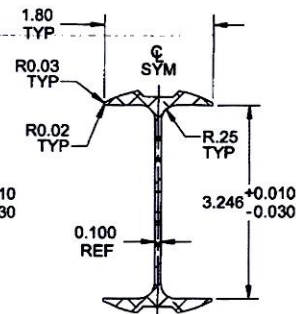
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DRAWN	RF	EUGENE, OR	
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3885	SHEET 2 OF 5
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DE APPR.	DS	WEB	NTS
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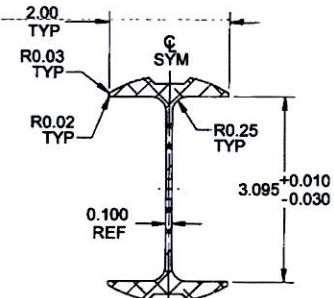
**SECTION A-A
& SECTION J-J** D6-2
D4-2
SCALE 5X



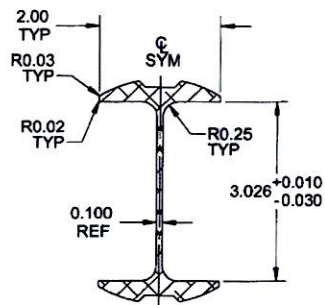
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SCALE 5X



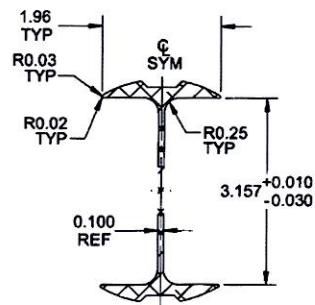
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SCALE 5X



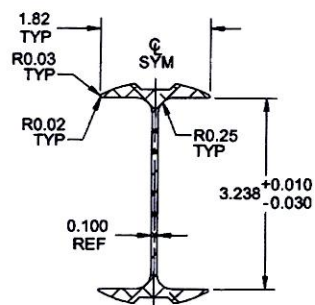
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SCALE 5X



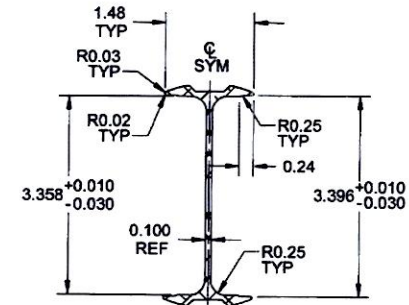
**SECTION E-E
& SECTION F-F** D5-2
SCALE 5X



SECTION G-G D4-2
SCALE 5X



SECTION H-H D4-2
SCALE 5X



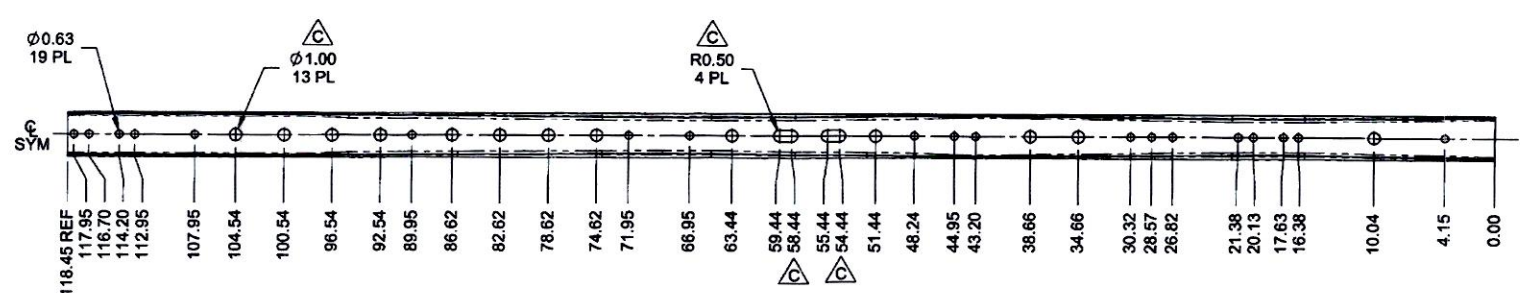
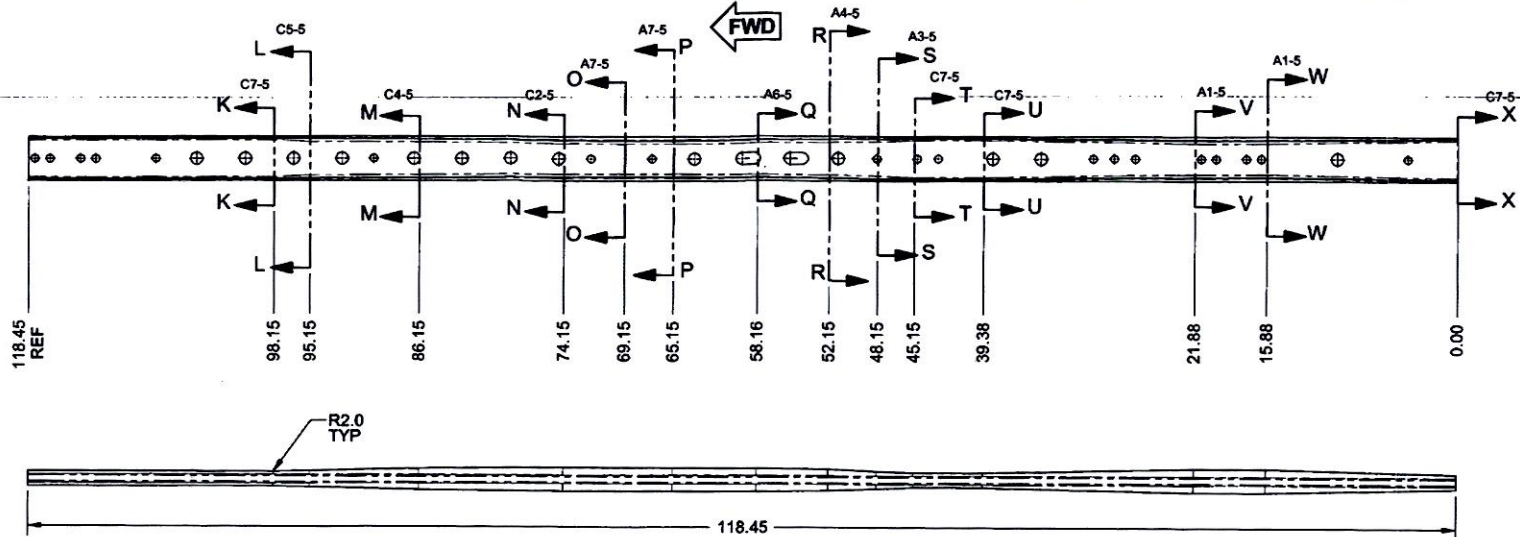
SECTION I-I D4-2
SCALE 5X

D3885-1 STANDARD WEB SECTION VIEWS

RELEASED
2016-02-26

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	EUGENE, OR	
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3885	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEB	NTS
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D3885-3 FLOAT WEB

D3885-3 NOTES:

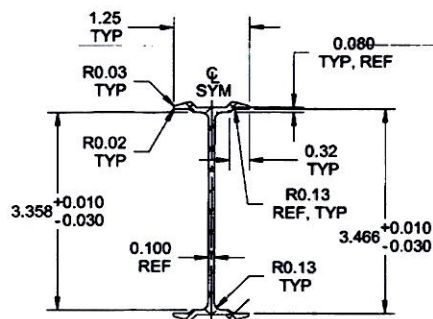
- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 004 6.1
- 7) WEIGHT: 10.14 lbs

RELEASED
2016-02-26

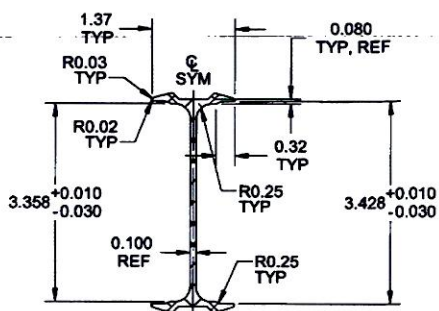
APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	EUGENE, OR	
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3885	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEB	NTS
DATE	16.02.18	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

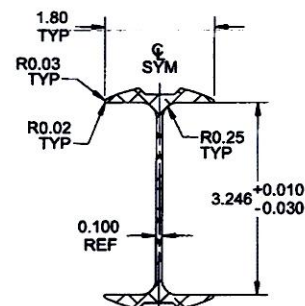
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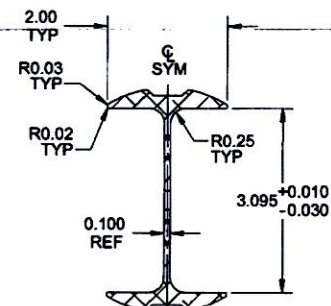
**SECTION K-K
& SECTION T-T
& SECTION U-U
& SECTION X-X**
SCALE 5X
D7-4
D4-4
D3-4
D1-4



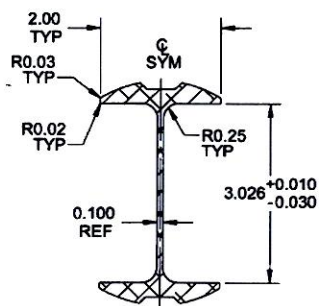
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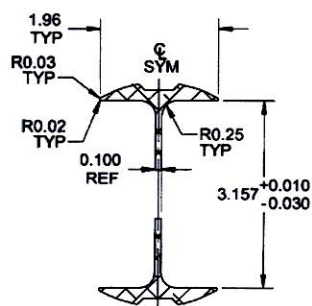
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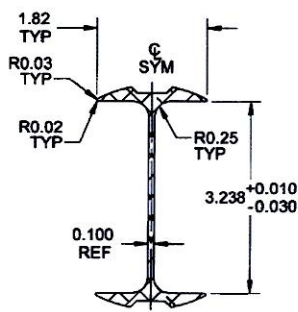
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SCALE 5X



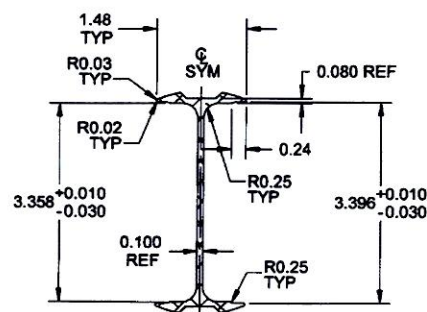
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& SECTION P-P** D5-4
SCALE 5X



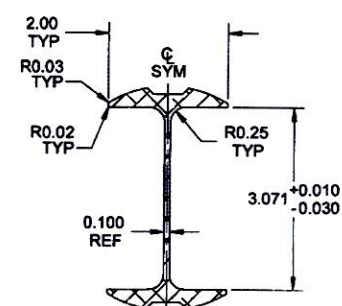
SECTION Q-Q D4-4
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SECTION R-R D4-4
SCALE 5X



SECTION S-S D4-4
SCALE 5X



**SECTION V-V
& SECTION W-W** D3-4
D2-4
SCALE 5X

D3885-3 FLOAT WEB SECTION VIEWS

RELEASED
2016-02-26

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	EUGENE, OR	
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3885	SHEET 6 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEB	NTS
DATE	16.02.18	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO34379

Purchase Order Date 11/21/2016 7:53:10 AM
PO Print Date 11/21/2016

Page Number 1 of 2

Order From :

VC-WMP001

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

NOV 21 2016

Contact Name

Vendor Phone

613-384-1662

Ship To Contact

Ship To Phone

Ship Via:

Journey Freight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3885-1P AS PER DWG D3885 REV. C B153347	Standard Web DAS 9 9-89	11/30/2016 Yes 11/30/2016		6.00 Each	\$495.00	\$2,970.00
Line Total:							\$2,970.00
3	D3885-1P AS PER DWG D3885 REV. C B152609	Standard Web	12/15/2016 Yes 12/15/2016		20.00 Each	\$495.00	\$9,900.00
Line Total:							\$9,900.00

Note:

11/21/2016



Packing Slip 38320
600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3
TEL: 613-384-1662 FAX: 613-384-2997
www.wejay.com

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Part Aerospace
1000 21st Street
Hawkesbury ON K6A 1K7

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Part Aerospace
1000 21st Street
Hawkesbury ON K6A 1K7

INVOICE DATE	YOUR ORDER NO.	DATE ORDERED	SHIPPED VIA
	34379	11/16/16	Best way
CUSTOMER CODE	PROV. LIC. NO.	Extra ☐ Exempt ☐	TERMS
0000			

QUANTITY ORDERED	B.O.	QUANTITY SHIPPED	DESCRIPTION	UNIT PRICE	AMOUNT
60	—	60	Standard web as per drawing D3885, Rev. C Reference #: D3885-10 B153347 REQUIRED BY: November 15, 2016		
20	—	20	Standard web as per drawing D3885, Rev. C Reference #: D3885-11 R153009 REQUIRED BY: December 13, 2016		
RELEASE NOTE I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order. Inspection Supervisor <u><i>[Signature]</i></u> WMP 03 Nov. 29/16					
				G.S.T.	
				P.S.T.	

ORDER: COMPLETE ☐
PARTIAL ☐

TOTAL

NO GOODS RETURNED WITHOUT PRIOR AUTHORIZATION

RECEIVED BY _____
1.5% PER MONTH (18% PER ANNUM)
CHARGED ON OVERDUE ACCOUNTS



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace		DATE: Nov. 29, 2016	
		P.O.# PO34379	
		WEJAY JOB# 38320	
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D3885-P1 'Standard Web' DAS 9 9-89	6	Machined supplied extrusions complete per drawing req'ts	D3885 sheets 2-3 / rev. C
Note: 1) Material supplied by Dart Aerospace. 2) First article Inspection Report attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Sincerely,

Clifford Smith
Authorized Q.A. Signatory



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 38320

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO34379

PART No. D3885-1P

DESCRIPTION: Standard Web

DWG No. D3885 - sheets 2-3

REV. C

E.C.O. --

MATERIAL: Extrusions supplied by DAS

INSPECTOR:
Paul Rousen/ Cliff Smith

QUANTITY
REC'D: 1

ACCEPT:
1

REJECT:
-

N.C.R.#
--

DATE: Nov. 29, 2016

INSTRUCTIONS, COMMENTS: **1st ARTICLE INSPECTION** / FINAL INSPECTION

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
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1	Hole, Ø .63"	18 places	+ .008/- .001		.6315	1	Accepted
2	Hole, Ø 1.00"	13 places	+ .010/- .001		1.0015	1	Accepted
3	Slot, R 0.50	2 places	+ .010/- .001		.5005	1	Accepted
4	5.51"		± .03		5.5128	1	Accepted
5	11.86"		± .03		11.8533	1	Accepted
6	13.11"		± .03		13.105	1	Accepted
7	15.61"		± .03		15.605	1	Accepted
8	16.86"		± .03		16.855	1	Accepted
9	22.29"		± .03		22.293	1	Accepted
10	24.04"		± .03		24.041	1	Accepted
11	25.79"		± .03		25.789	1	Accepted
12	30.14"		± .03		30.1315	1	Accepted
13	34.14"		± .03		34.1305	1	Accepted
14	38.67"		± .03		38.663	1	Accepted
15	40.42"		± .03		40.4115	1	Accepted
16	43.71"		± .03		43.7045	1	Accepted
17	46.91"		± .03		46.902	1	Accepted
18	49.91"		± .03		49.903	1	Accepted
19	50.91"		± .03		50.903	1	Accepted
20	53.91"		± .03		53.906	1	Accepted
21	54.91"		± .03		54.904	1	Accepted
22	58.91"		± .03		58.903	1	Accepted
23	62.43"		± .03		62.4265	1	Accepted
24	67.43"		± .03		67.4255	1	Accepted
25	70.10"		± .03		70.09	1	Accepted
26	74.10"		± .03		74.091	1	Accepted
27	78.10"		± .03		78.0905	1	Accepted
28	82.10"		± .03		82.0905	1	Accepted
29	85.43"		± .03		85.428	1	Accepted

INSPECTION / TEST REPORT						JOB No. 38320	
						PAGE: 2 of 3	
CUSTOMER: Dart Aerospace							
CUST. P.O PO34379							
PART No.D3885-1				DESCRIPTION: Standard Web			
DWG No. D3885 - sheets 2-3				REV. C		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

30	88.01"		± .03		88.0075	1	Accepted
31	92.01"		± .03		92.006	1	Accepted
32	96.01"		± .03		96.005	1	Accepted
33	100.01"		± .03		100.004	1	Accepted
34	103.43"		± .03		103.4225	1	Accepted
35	108.42"		± .03		108.411	1	Accepted
36	109.67"		± .03		109.660	1	Accepted
37	112.17"		± .03		112.1595	1	Accepted
38	113.42"		± .03		113.4075	1	Accepted
39	113.92" o.a.		± .03		113.9085	1	Accepted
40	1.25" TYP	Section A-A, J-J	± .03		1.273	1	Accepted
41	R.03" TYP		± .03		.03	1	Accepted
42	R.02" TYP		± .03		.02	1	Accepted
43	3.358"		+0.010/-0.030		3.356	1	Accepted
44	R.13" TYP		± .03		.130	1	Accepted
45	.32" TYP		± .03		.320	1	Accepted
46	3.466"		+0.010/-0.030		3.464	1	Accepted
47	R.13" TYP		± .03		.130	1	Accepted
48	.080 TYP,REF		± .03		.080	1	Accepted
49	1.37" TYP	Section B-B	± .03		1.390	1	Accepted
50	R.03" TYP		± .03		.03	1	Accepted
51	R.02" TYP		± .03		.02	1	Accepted
52	3.358"		+0.010/-0.030		3.354	1	Accepted
53	R.25" TYP		± .03		.250	1	Accepted
54	.32" TYP		± .03		.320	1	Accepted
55	R.25" TYP		± .03		.250	1	Accepted
56	3.428"		+0.010/-0.030		3.425	1	Accepted
57	1.80" TYP	Section C-C	± .03		1.820	1	Accepted
58	R.03" TYP		± .03		.03	1	Accepted
59	R.02" TYP		± .03		.02	1	Accepted
60	3.246"		+0.010/-0.030		3.242	1	Accepted
61	R.25" TYP		± .03		.250	1	Accepted
62	2.00" TYP	Section D-D	± .03		1.986	1	Accepted
63	R.03" TYP		± .03		.03	1	Accepted
64	R.02" TYP		± .03		.02	1	Accepted

INSPECTION / TEST REPORT						JOB No. 38320	
						PAGE: 3 of 3	
CUSTOMER: Dart Aerospace							
CUST. P.O PO34379							
PART No. D3885-1				DESCRIPTION: Standard Web			
DWG No. D3885 - sheets 2-3				REV. C		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

65	3.095"		+ .010/- .030		3.0935	1	Accepted
66	R.25" TYP		± .03		.250	1	Accepted
67	2.00" TYP	Section E-E, F-F	± .03		1.985	1	Accepted
68	R.03" TYP		± .03		.03	1	Accepted
69	R.02" TYP		± .03		.02	1	Accepted
70	3.026"		+ .010/- .030		3.029	1	Accepted
71	R.25" TYP		± .03		.250	1	Accepted
72	1.96"	Section G-G	± .03		1.970	1	Accepted
73	R.03" TYP		± .03		.03	1	Accepted
74	R.02" TYP		± .03		.02	1	Accepted
75	3.157		+ .010/- .030		3.152	1	Accepted
76	R.25" TYP		± .03		.250	1	Accepted
77	1.82"	Section H-H	± .03		1.830	1	Accepted
78	R.03" TYP		± .03		.03	1	Accepted
79	R.02" TYP		± .03		.02	1	Accepted
80	3.238"		+ .010/- .030		3.240	1	Accepted
81	R.25" TYP		± .03		.250	1	Accepted
82	1.48"	Section I-I	± .03		1.495	1	Accepted
83	R.03" TYP		± .03		.03	1	Accepted
84	R.02" TYP		± .03		.02	1	Accepted
85	3.358		+ .010/- .030		3.356	1	Accepted
86	R.25" TYP		± .03		.250	1	Accepted
87	3.396"		+ .010/- .030		3.393	1	Accepted
88	R.25" TYP		± .03		.250	1	Accepted